Tuesday, 11/6/2007 1:25:49 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 35566

This Issue

Prsht Rev.

Estimate Number : 12719

P.O. Number

: 11/6/2007

S.O. No. :

: NC

First Issue Previous Run : // : 32741

Type

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D353625 · D3536 REV A

: GASKET

: N/A

Project Number : A **Drawing Revision**

Material

: 11/16/2007 **Due Date**

Qty:

30 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev.

New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063

Comment: Qty.:

0.6254 sf(s)/Unit

Total:

18.7614 sf(s)

NEOPRENE SHEET 0.063

Batch:

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:_

Prog Rev:_

B 07-11-12



2-Deburr if necessary

3.0

QC2

B07-11-13



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

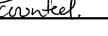


Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

h 1/11/14



Dart Ae	rospace	Ltd							
W/O:		1	· · · · · · · · · · · · · · · · · · ·	V	ORK ORDER CHANGES				
DATE	STEP	1	PR	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No	:	† 	PAR #:	Fault Cat	egory:N	CR: Yes	No DQA:	Date: _	· · · · · · · · · · · · · · · · · · ·
		1	!			QA: N/	C Closed:	Date: _	
NCR:				WORK OR	DER NON-CONFORMANC	E (NCR)		
		Des	scription of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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NCR:				WORK ORDI	ER NON-CONFORMAN	SE (NCR)			
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NOTE: Date & initial all entries

Date:

Tuesday, 11/6/2007 1:25:49 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Part Number: D353625

Job Number: 35566

Seq. #:

Job Number:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 8911114

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	355(do
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	28.16				
16.35	+/-0.030	16.35				
10.90	+/-0.030	10.90				
5.45	+/-0.030	5.45				
6.00	+/-0.030	6.00			•	
6.75	+/-0.030	6.75				
12.75	+/-0.030	13.75				
1.89	+/-0.030	1.89				
0.30	+/-0.030	,36				
0.30	+/-0.030	-30 -				
Ø0.19	+0.005/-0.001	,(9				
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07 - 1(-12	Date: / (4·1(·(3	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM	R

8 11.20

26.65 23.15 21.15 17.65 13.40 -9.15 0.90 - 5.65 1.89 DETAIL A 3.90 Ø0.19 14.00 (TYP 3 PLS)

D3536-11 GASKET

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY ENGINEERING RETURN TO

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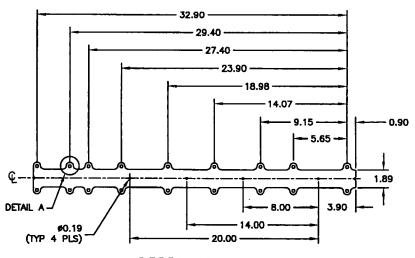
PURPOSE

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COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-13 GASKET

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GASKET



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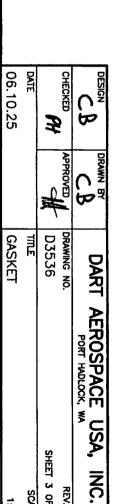
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 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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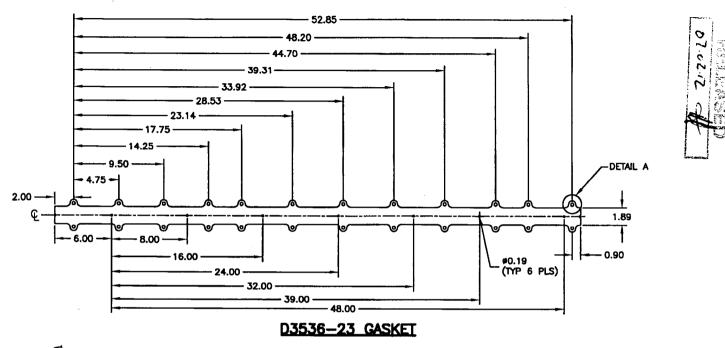
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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
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D3536-25 GASKET

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D3536-33 GASKET

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D3536-35 GASKET

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뒾s DOCUMENT 30.75 Copyright © 2006 by DART AEROSPACE US IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT I OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM 27.25 21.02.12 22.50 2.00 4.75 1.89 6.00 8.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) CHECKED 06.10.25 DATE D3536-37 GASKET B 3 DRAWN BY APPROVED 35.71 32.78 29.28 D3536 25.78 GASKET DRAWING NO. DART ZSZ. 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063) DART NOT 2) FINISH: NONE INC.

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D3536-41 GASKET

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1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
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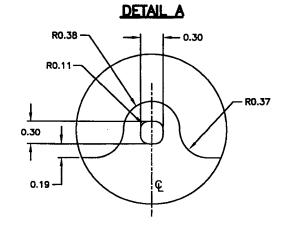
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